

Work Order ID 70747

Tuesday, June 14, 2011 10:03:52 AM



Page 1

Item ID: D4306-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: ME

Date: 11-06-14

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4306	C								

100 Weld per dwg A/R S.S. rod Batch: 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut tube 50"
- 2- Bend tube with manual pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D4306-5
- 4- Drill and chamfer holes as per dwg D4306-5 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

SAD 11-06-14

11.06.14



110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/6/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 14, 2011 10:03:50 AM

Page 1

Work Order ID: 70747

Parent Item: D4306-045

Parent Item Name: Rib Assembly

Start Date: 6/14/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1		Manufactured	No			100	Each	311.0000	4	4			
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Bushing

Location	Loc Qty	Loc Code
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WA	200	
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69202	200	
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WA005	111	
-------	-----	--

66489	2	
-------	---	--

66870	109	
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M304TS0.750W.049

Purchased

No

100

f

342.6410

4.166

4.385263



304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
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MAT018	307.3439	
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117029	17.2454	
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117690	91.3618	
--------	---------	--

117775	198.7367	
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MAT034	35.2971	
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117337	35.2971	
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11.06.14

4

SAH 11-08-14

4.3853

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

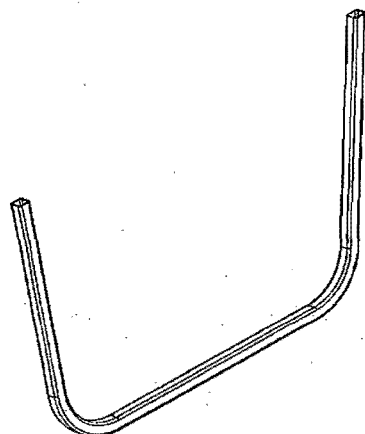
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

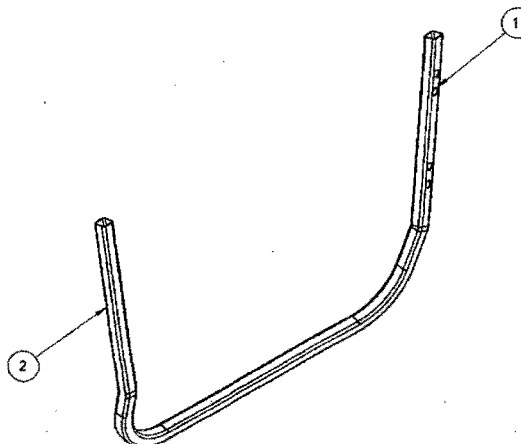
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

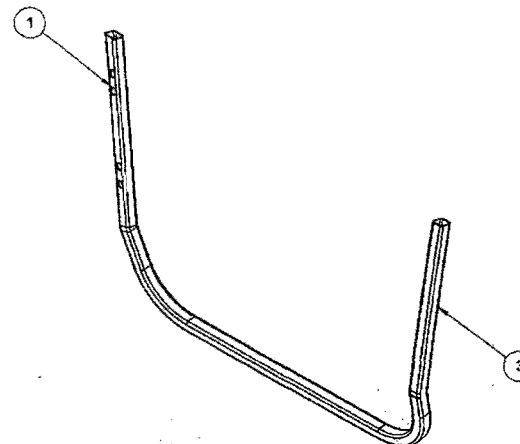
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



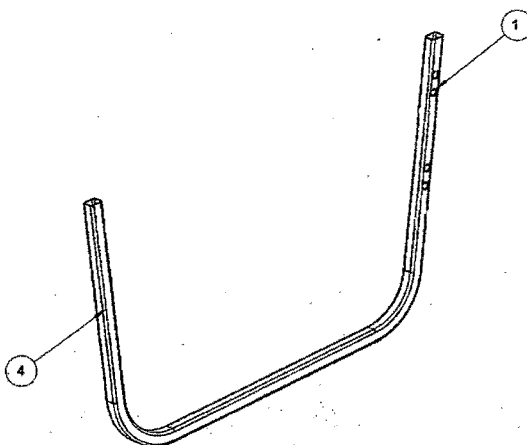
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



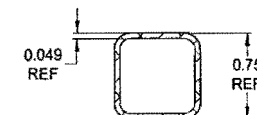
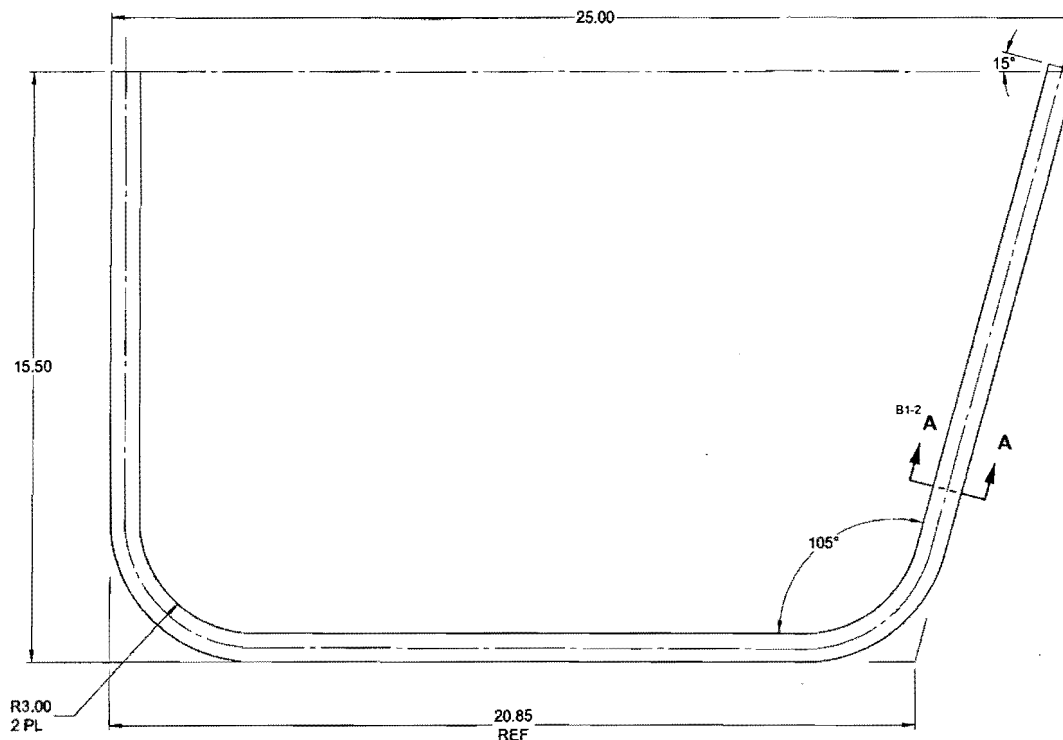
D4306-045 RIB ASSY

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4306 TITLE RIB SCALE NTS
DRAWN	SC	
CHECKED	SC	
MFG. APPR.	SC	
APPROVED	SC	
DE APPR.	SC	REV. C
DATE	11.02.09	SHEET 1 OF 8

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2011-03-18



SECTION A-A B4-2

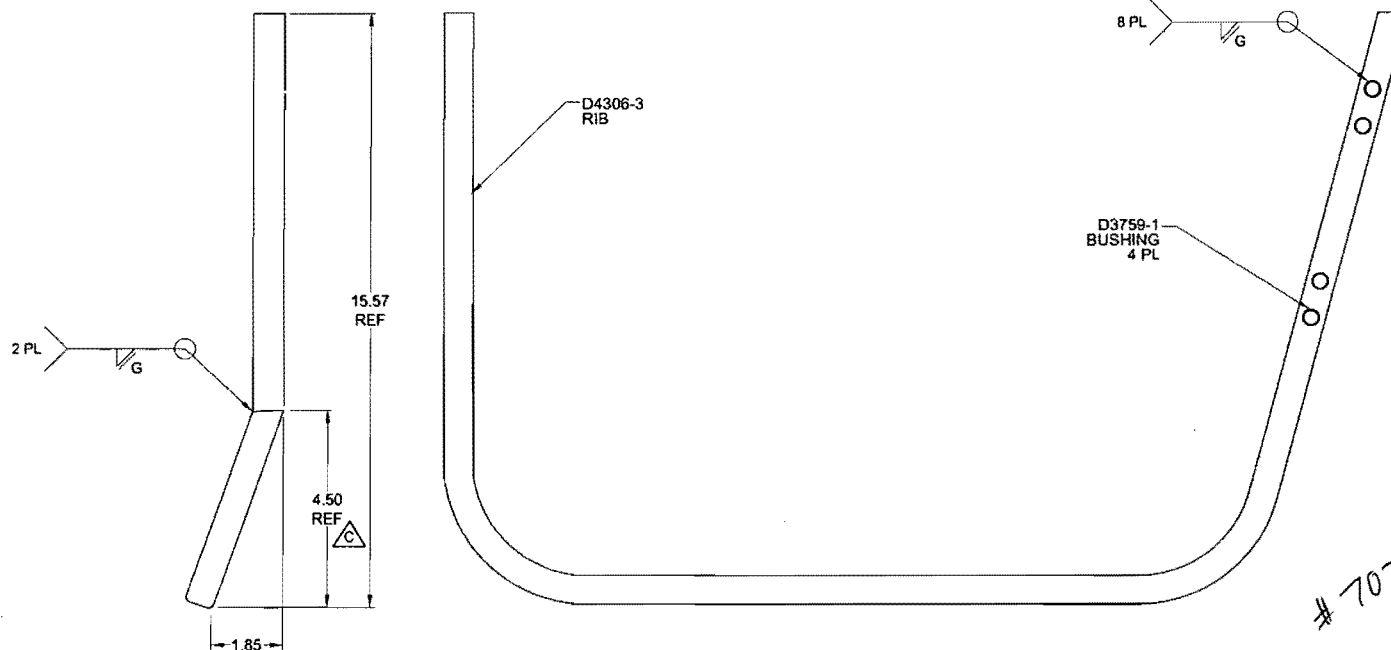
#70747

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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CHECKED		DRAWING NO. D4306	REV. C SHEET 2 OF 8
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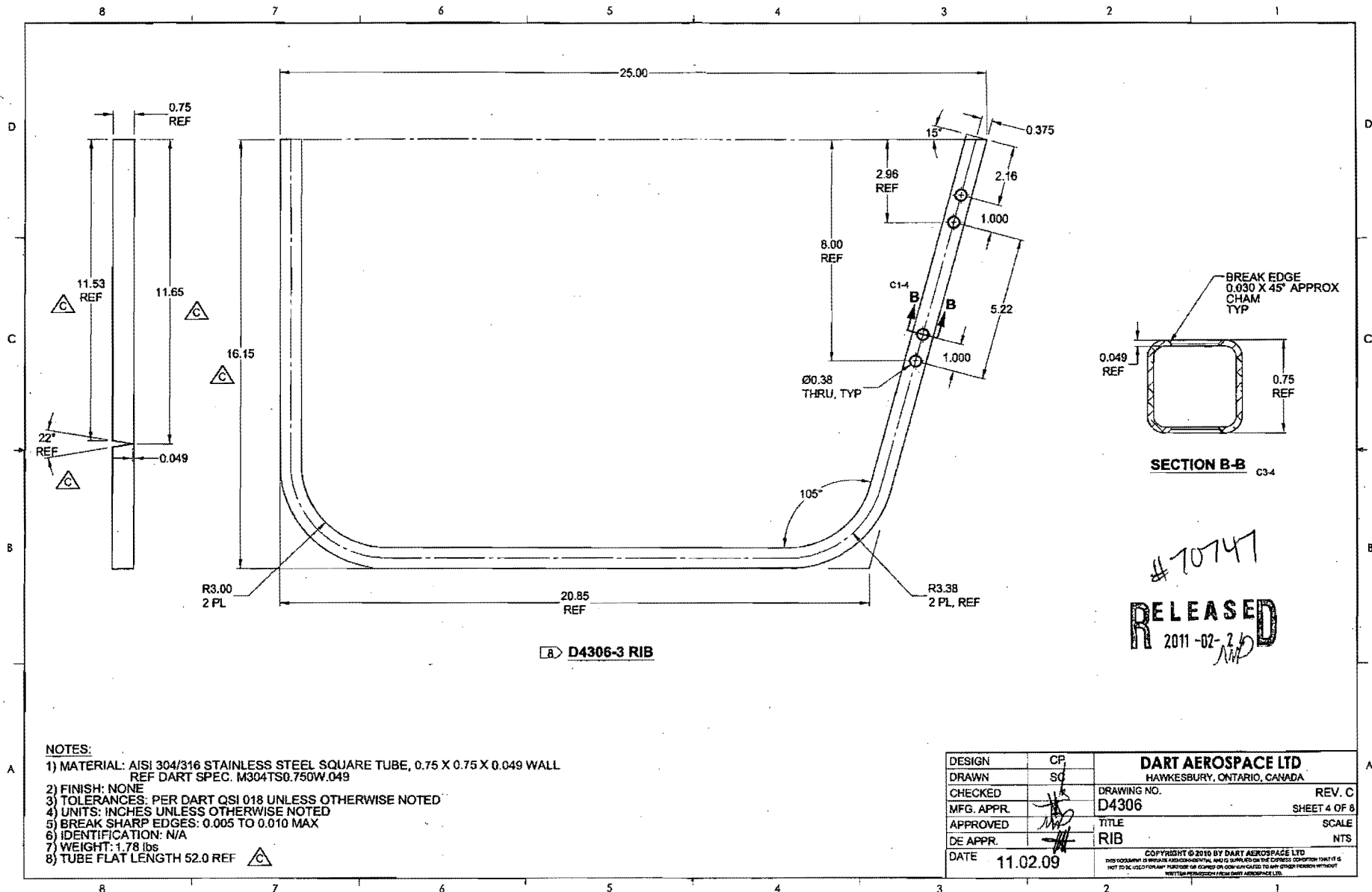
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RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

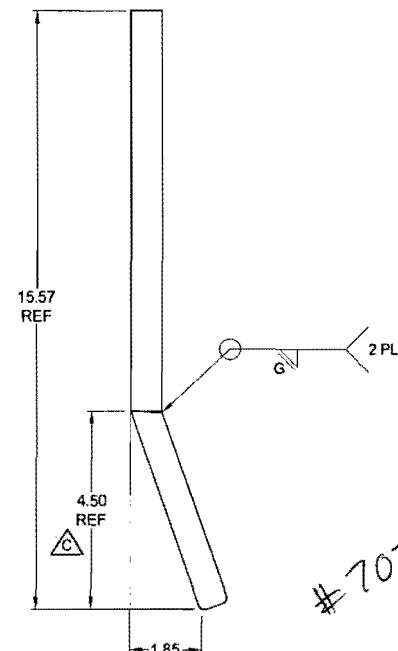
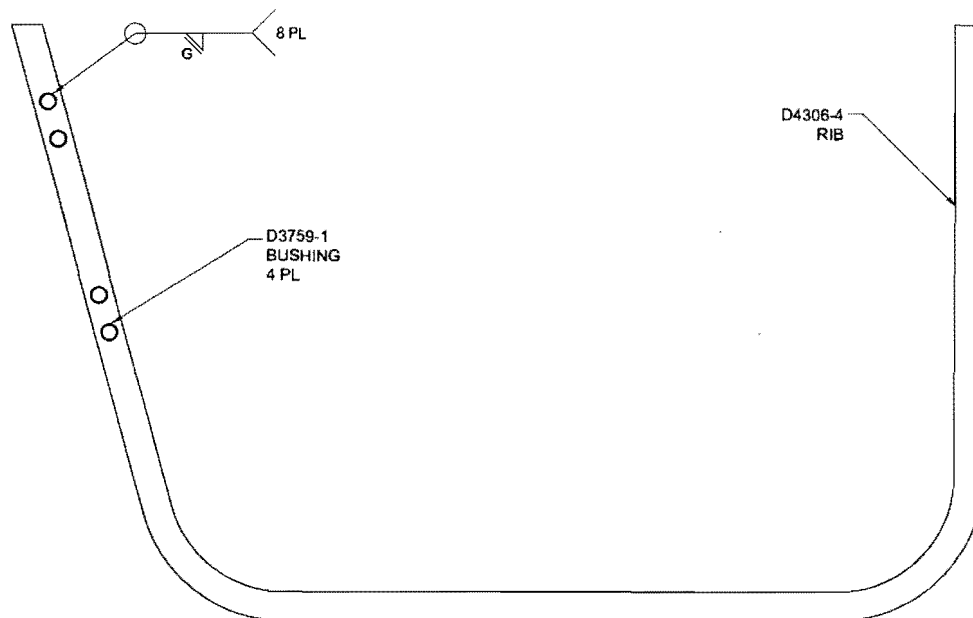
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MFG. APPR.		D4306	SHEET 3 OF 8
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DE APPR.		RIB	NTS
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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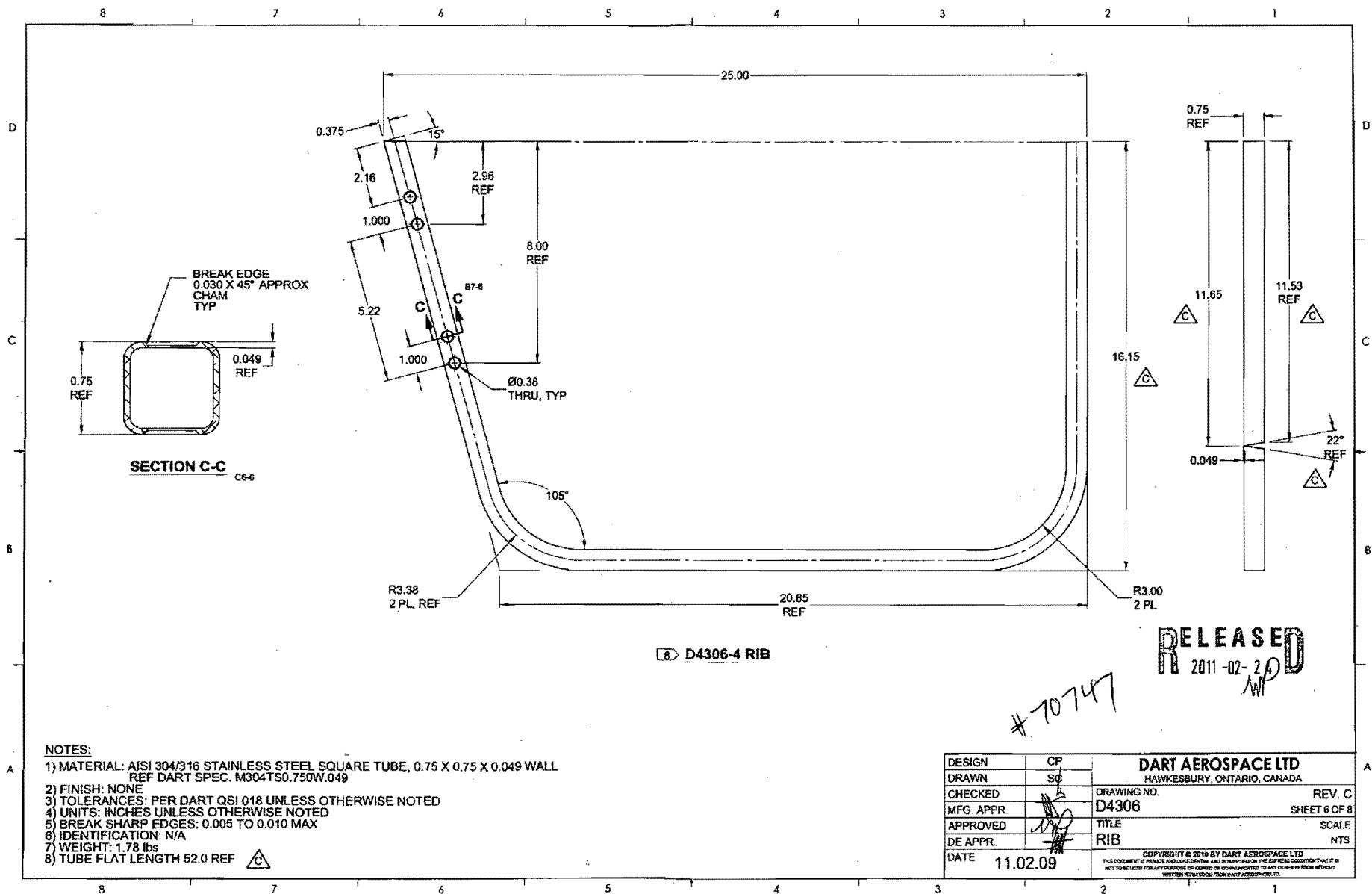
D4306-044 RIB ASSY, RH

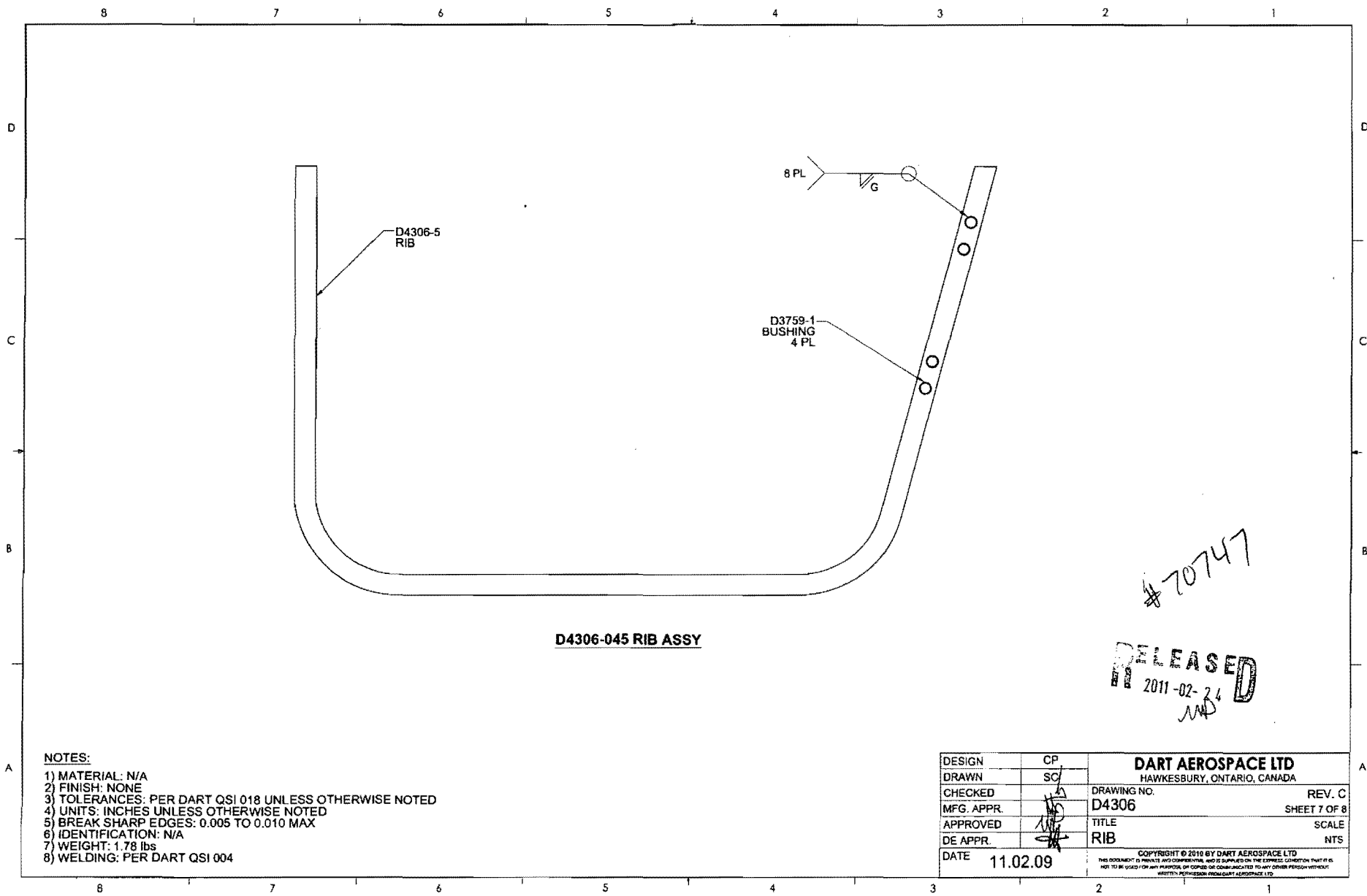
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RELEASED
 2011-02-24
 WJD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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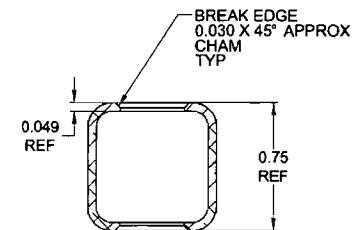
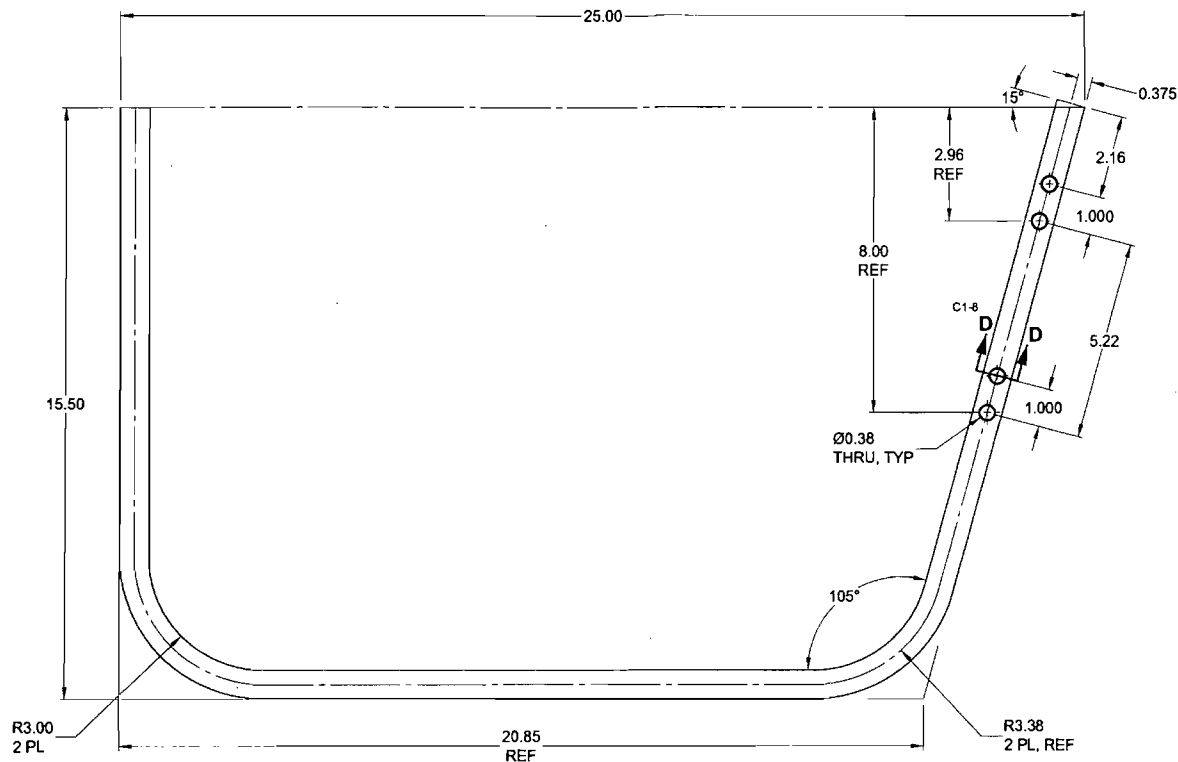
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NOTES:

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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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SECTION D-D C3-8

70147
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2011-02-24

8 D4306-5 RIB

NOTES:

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REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO.	REV. C
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